

# Work Order ID 56837

March 10, 2010 3:51:37 PM



Page 1

Item ID: D3773-041

Accept



Setup Start



Revision ID:

Item Name: Headrest Assembly

Stop



Start Date: 10/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

*R*

Date: 10-3-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr Revision Nbr

D3773 Rev B

100 Pick Kit



Packaging

Packaging

110



Large Fab

Large Fab

Large Fab

0.00

0.00

Memo

0.00

1- locate top hole with a 3/16" dowel pin and tack weld D3773-1 adapter to  
D3773-3 leg as per dwg D3773 \*\*\*\*take dowel pin out before welding\*\*\*\*  
2- weld as per dwg D3773 QSI004 316 S.S. Welding Rod  
Batch: M108160 3- if necessary

*EL 10-4-5 X6*

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*5/6/04/07*

0.00

*EL 10-4-5 X6*

*(B)*

*f3*

*P10 ->*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3773-3 PAR #: B56862 Fault Category: Machining NCR Yes No DQA: 1 Date: 16-04-07  
 Resolution: Scvnd Disposition: Scvnd QA: N/C Closed: HJ Date: 16/04/12

NCR: 56837		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
16/04/06	# 120	During inspection Found that QH x 3 welds assembly donot correspond to drawing. the .201" hole doesn't line up with the .257" holes.	16/04/06	-Scrap & Destroy QH x 3 parts that have D3773-3 B56862 welded to them. - No Replace (will replace on new w/o)	EL 16-04-06	S 16/04/06	16/04/06	S 16/04/06
		- welder didn't notice the problem before welding D3773-1 to D3773-3. Q.C. D3773-3 B56862 were machine wrong & impacted	16/04/06	- Pull w/o + other D3773-3 B56862 that was machine that is in stock & scrap	EL 16-04-06	S 16/04/06	16/04/06	S 16/04/06
		R.C. 104	16/04/06	- Retrain both parties involves to be more attentive to drawing when inspecting.	EL		16/04/06	S 16/04/06

NOTE: Date & initial all entries

**Work Order ID 56837**

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Item ID: D3773-041

Accept



Setup Start



Revision ID:

Item Name: Headrest Assembly

Stop



Start Date: 10/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							

QC

Quality Control

PD 10.04.05

140



Packaging

Packaging

Identify as per dwg & Stock Location: ST192

0.00

Rao/4/8 (3)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/12 AF

U 1004.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Picklist Print**

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Work Order ID: 56837



Parent Item: D3773-041



Parent Item Name: Headrest Assembly

Start Date: 10/03/2010

Required Date: 17/03/2010

Comments: IPP Rev:A 08-05-21 new issue DD verified by:ec  
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3773-1  Adapter		Manufactured	No			100	Each	8.0000	6.0000		EZ	10-4-5

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

8

54799

8

D3773-3

Manufactured No

110

Each

4.0000 6.0000

6

Leg

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

4

40997

1

54800

3

3

56862

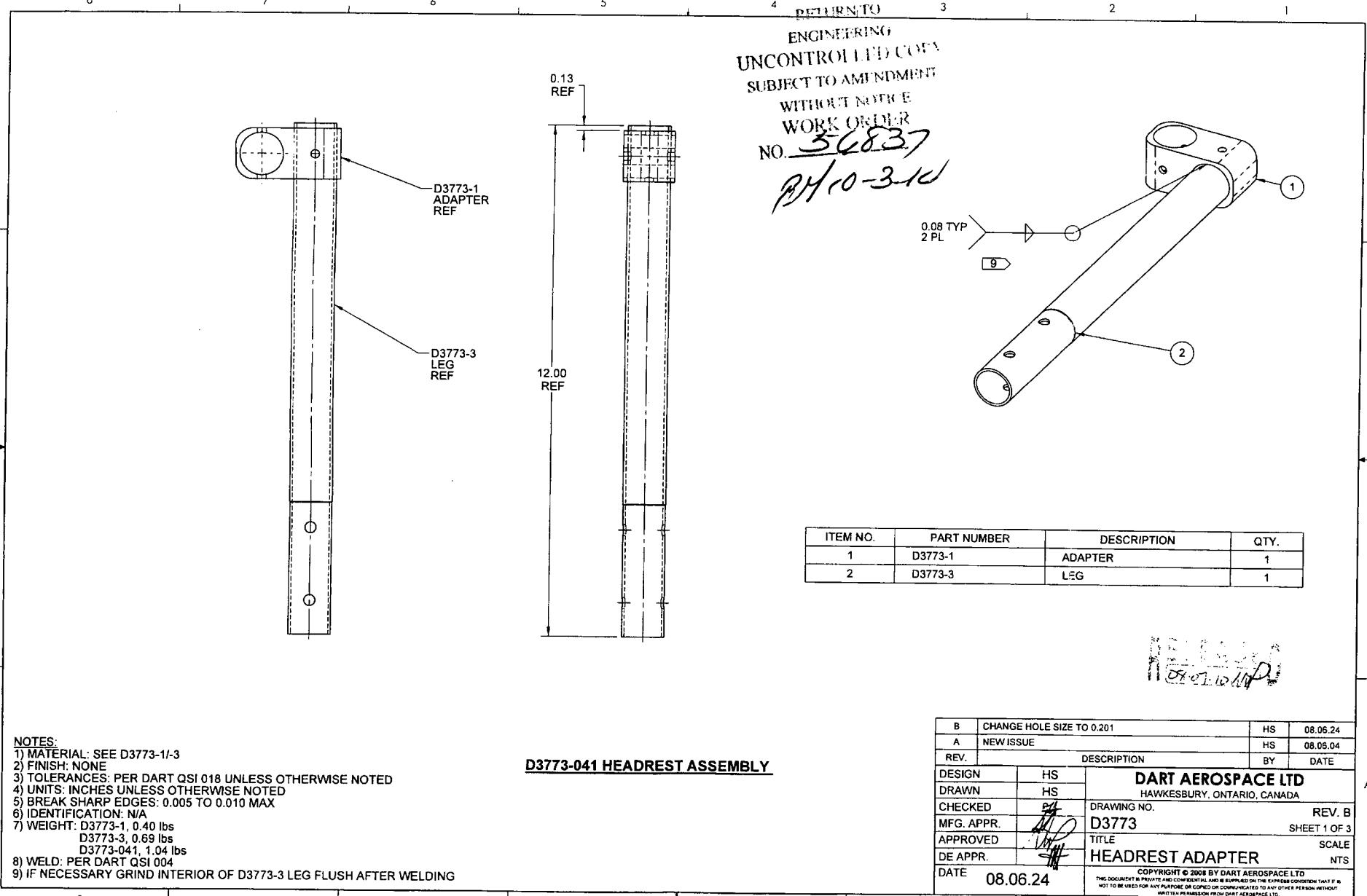
3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

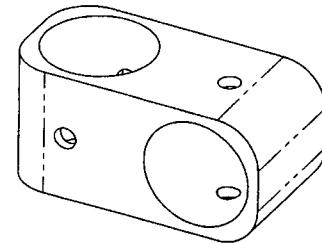
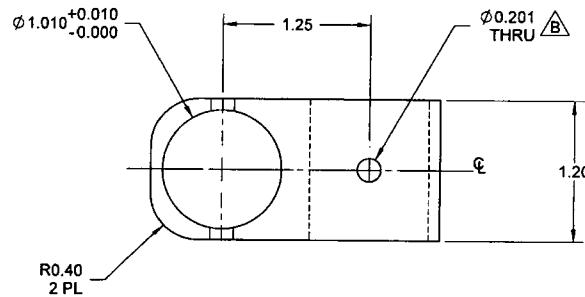
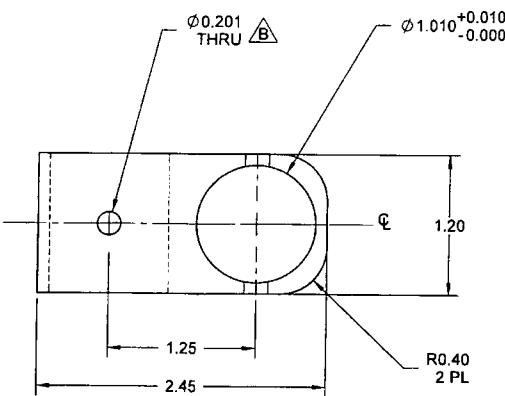
A

D

C

B

A

D3773-1 ADAPTER

A

## NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

110 56837

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	✓		
MFG. APPR.	✓	DRAWING NO.	REV. B
APPROVED	✓	D3773	SHEET 2 OF 3
DE APPR.	✓	TITLE	SCALE
DATE	08.06.24	HEADREST ADAPTER	NTS

08-07-10 14:45

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8 7 6 5 4 3 2 1

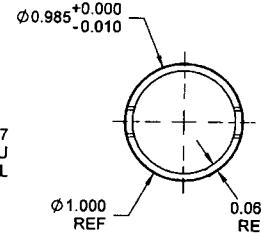
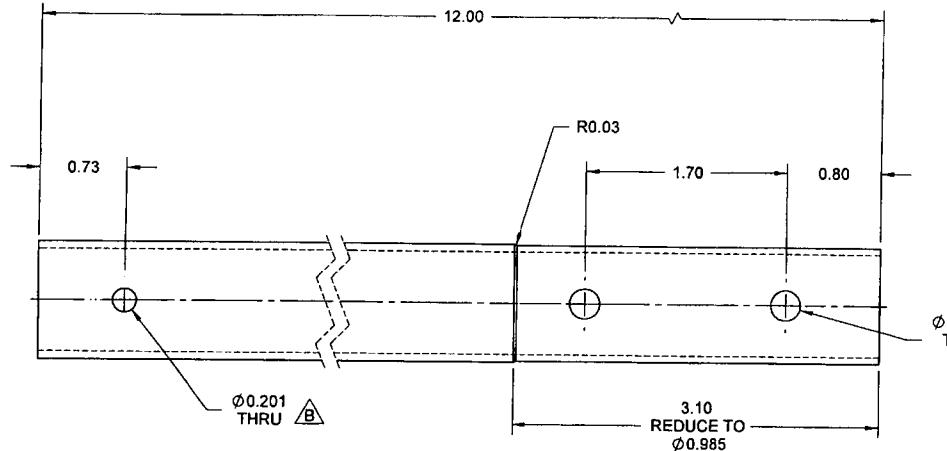
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3773-3 LEG

**NOTES:**  
1) MATERIAL: AISI 304/316 SS TUBING  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 U  
4) UNITS: INCHES UNLESS OTHERWISE  
5) BREAK SHARP EDGES: 0.005 TO 0.010  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.69 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKSLEY, ONTARIO, CANADA		
DRAWN	HS			
CHECKED	<i>PD</i>	DRAWING NO.		
MFG. APPR.	<i>PD</i>	D3773	REV. B	
APPROVED	<i>APD</i>	SHEET 3 OF 3		
DE APPR.	<i>APD</i>	TITLE		SCALE
DATE	08.06.24	HEADREST ADAPTER		NTS

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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